Work Order II January-30-14 11:43			*112	450*						Page 1
Item ID: D358 Revision ID: Item Name: Joggl	80-1 e Bracket		Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Star Stop	1 7	S1* S2*
Start Date: 1/30/ Required Date: 1/30/ Reference:	~ •			Cust Item I Customer:	D:					
	cess Plan:	Date: <u>                                     </u>	Tooling: SPC (Y/N):		ate:		R	tun Star Stop	, ^IV	R1* R2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									-
D3580	Rev B									
*100  *100* Waterjet  FLOW CNC Waterjet  304.050.	Dwg Rev Prog Rev	per Dwg D3580 :	0.00				40	_6_		<u> Jm14-</u> c3-11
110 <b>*1 1                                  </b>	-QC2- Inspect parts off  Memo	f machine FAI/FAIB	0.00				40	_٥_		<u>dm14</u> -03-
120 *120* QC .	QC8- Inspect parts - s . Memo	econd check	0.00 PAS 0.00 PAS 0.00 PAS	))			40 60 A			

DQA: Date:						- WORK ORDER NON CONFORMANCE (URDATE									
QA Closed:			Date:			WORK ORDER NON-	-CC	ONFO	RMANCE / UP		Mork	Order un	date only		AEROSPACE
QA Closeu.			Date.		··· - ···		_			,	VVOIR	Order up	uate only		
Work Orde	er:					DISPOSITION			AGAINST DEPARTMENT/PROCESS						
	•					Rework			Skid-tube Crosstube			Water Jet			Engineering
Part N	lo.					Scrap			Machining Small Fab			Prod. Eng. Coor.			Quality
	•				_	Use-as-is			noforming	Finishing			e/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite			Supplier	$\neg$	
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Root					Desc	ription of work order update	ı	nitial	Acti	on		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	╝	QC Inspector
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Unapproved			<u> </u>	<u> </u>			<u> </u>	III T CA'	TECORY						
1				•		Cananal	FA	ULT CA	TEGORY					—	
Landi	_	1			Г	General Bend		احمانه (د	Program	Г	$\neg$	utside Dim	ensions [	—	Pressure/Forced
	Bending			BOM/Route	$\vdash$	Grain	Togram	ŀ		ver/Under	-	_	Set-up		
	Centre Not Concentric		-	Broken/Damage/Defect	$\vdash$	Hardwa	are	ŀ	_	rt Incorrec	- t		Temperature/Cure		
	Cracks Crimp/Kink/Ripple/Wave		-	Burrs	$\vdash$	4	tion Incomplete/Un	gualified	— i	rt Lost/Mi	F		Weld		
	-	Cuffs	"A rabbic	, ***		Contamination	$\vdash$	1 '	tions Incomplete/U	·	_	rt Moved	6		Wrong Stock Pulled
	_	Crushing			<b> </b>	Countersink		<b>-</b> I	gned/off center		_	sitioned V	L Vrong		
	-	Heat Trea	at			Cut Too Short		Mislab	=	}		ower Loss/	r		Other
	<u> </u>	Inspectio		Tube		Drawing		Misrea		L		•	- L		· · · · · · · · · · · · · · · · · · ·
	一	Marks/Ch	-			Drill Holes		Off-set			_			_	
,		Turning S				Finish		4	Calibration				· · · · · · · · · · · · · · · · · · ·		
}		Wave/Tw	-			Fit/Function		Out of	Sequence		_				

	P.			1000						-		
Work Order January-30-14 11		2450		*112	2450*							Page 2
Revision ID: Item Name: Jo	3580-1 oggle Bracket			Accept	*N900	<b>040</b>	100	<b>)</b> * ፡	Setup	Start Stop	*N:	S1* S2*
Start Date: 1, Required Date: 1, Reference:	/30/14	Start Qty: 40.00 Req'd Qty: 40.00	*40* *40*		Cust Item I Customer:	D:	_	_	_	C44		
Approvals:	Process Plan	n:!	Date:	Tooling:	D	ate:		1	Run	Start	*N	R1*
•	QC:		Date:	<b>SPC (Y/N):</b>	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
130 <b>*1.20*</b> Small Fab		Small Fab		0.00		DAS <b>30</b> 9 <b>-8</b> 6		42				14631
Small Fab			dwg D3580 using 1/8" off	fset die					•			
<sup>140</sup> <b>*1⊿∩*</b>		QC5- Inspect part comple	eteness to step on W/O	0.00 <b>27</b> ,				40				
QC Quality Control		Мето		0.00 MB	112			can				
150		Identify as per dwg & Sto	ock Location:	0.00					/		DAS	
*150* Packaging Packaging		Memo	57 50	0.00				17/	3/1	2	Das 32 <del></del>	(40)

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Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
	-					Rework		Skid-tube Crosstub			1	Water Jet	Engineering
Part N	١o.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	•				_	Use-as-is		Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR N	۱o.				_	Suspected Unapproved			Large Fab	Composite	]	Supplier	
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		Bending			-	Bend BOM (Boute	_	4	Program	<u> </u>	Outside Dim	<b>—</b>	Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric	-	BOM/Route	⊢	Grain		-	Over/Under	<b>—</b>	Set-up
	$\vdash$	Cracks	-1./D:1-	. /\4/=		Broken/Damage/Defect	⊢	Hardwa			Part Incorred	<b>—</b>	Temperature/Cure Weld
	<del> </del>	Crimp/Kii	пк/кірріе	ywave	-	Burrs	$\vdash$	-i	ion Incomplete/Unq		Part Lost/Mi	SSING	
	-	Cuffs				Countarion	$\vdash$	-	tions Incomplete/Un	nciear	Part Moved	L Vrang	Wrong Stock Pulled
	$\vdash$	Crushing			$\vdash$	Countersink Cut Too Short	┝	Mislabe	gned/off center	-	Positioned V Power Loss/		Other
	$\vdash$	Heat Trea		Tubo	-	₫	-	Misrea		<u> </u>	Trower ross/	Juige	Tottlei
	-	Marks/Ch	•	rube	$\vdash$	Drawing Drill Holes	$\vdash$	Off-set					
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	evision ID:  em Name: Joggle Bracket  art Date: 1/30/14 Start Qty: 40.00 */ equired Date: 1/30/14 Req'd Qty: 40.00 */ eference:  Deprovals: Process Plan: Date: QC: Date:  quence ID/ ork Center ID Description  OC21- Final Inspection - Work Order Release			*112450*							Page 3	
Item ID: Revision ID: Item Name:		et		Accept	*N900	04010	<b>^^</b>	Setup	Start Stop	*N.9	S1* S2*	
Start Date: Required Date: Reference:			*40* *40*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling:	Da	nte:		Run	Start	*NI	<b>२</b> 1*	
	QC:		Date:	SPC (Y/N):	Da	nte:			Stop	*NI	<b>ヲ</b> 2*	
Sequence ID/ Work Center II	D	Description	Work Order Release	Set Up/ Run Hours	Tool ID	Tool # Pla		pt Rej Qty		Reject Number	Insp. Stamp	_
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Part N	lo.					Scrap	1 1		<b>⊢</b>	mall Fab	Prod	d. Eng. Coor.	Quality		
	-					Use-as-is	1		~ <del></del>	Finishing		e/Packaging	Other		
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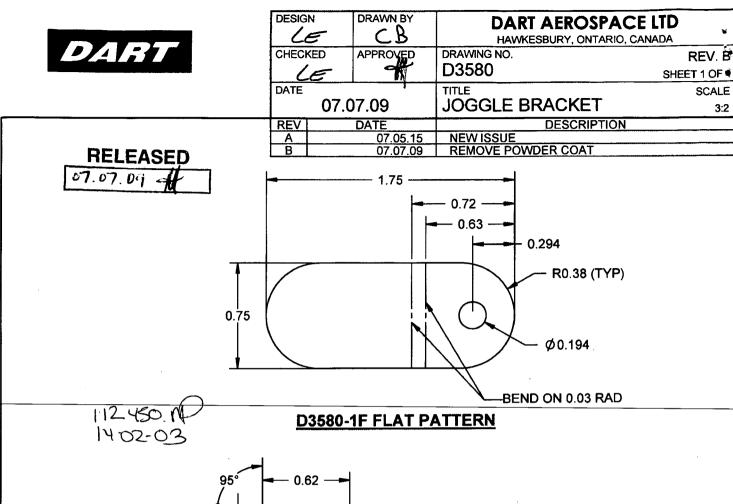
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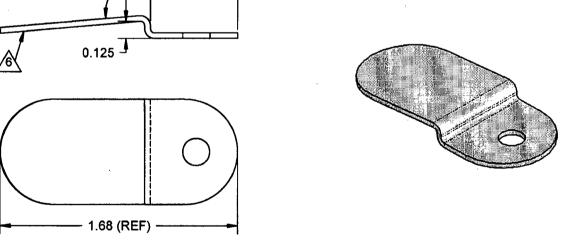
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QA Closed:			Date:							Wo	ork Order up	date only			
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		Crimp/Ki	nk/Ripple	e/Wave		Burrs	<u>_</u>	<b>-</b> 1 '	tion Incomplete/Unqu	<u> </u>	Part Lost/Mi	ssing	Weld		
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i		Crushing				Countersink	<u></u>	<b>-</b> 1	gned/off center		Positioned V	ļ	<b>¬</b>		
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DART AEROSPACE LTD	Work Order:	112450
Description: Joggle Bracket	Part Number:	D3580-1
Inspection Dwg: D3580 Rev: B		Page 1 of 1

Inspection Dwg:	: D3580 Rev:	B				Pa	ge 1 of 1
	FIRST	ARTICLE IN	SPECTION	ON CHE	CKLIST		
	X	7		Proto			
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Соі	nments
Ø0.194	+0.005/-0.001	0.1950			U	Jano	ı <u></u>
1.75	+/-0.030	1.753	-		V		
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leasured by:	m	Audited by:	27		Prototype Ap	proval:	N/A
Date:	4-03.11	Date:	14/3			Date:	N/A
Rev Date	Change		, 1/2	• ]	Revi	sed by.	Approve

Rev	Date	Change	Revised by	Approved
Α	07.10.30	New Issue	KJ/EC/DD	X





## **D3580-1 JOGGLE BRACKET**

- NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 18 GAUGE (0.050 THICK) PER MIL-S-5019 (REF DART SPEC M304S18GA)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX
- IDENTIFY WITH DART P/N "D3580-1" USING FINE POINT PERMANENT INK MARKER ON THE UNDERSIDE OF THE PART AS INDICATED

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